

16/07/11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 148186

Monday, June 27, 2016 11:40:35 AM

148186

Page 2

Item ID: DSK078

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: D2893-1 Turning Detail

Start Date: 6/28/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 7/11/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130						8	20		DAS 14
Packaging	Memo	0.00							9-89
Packaging	LOCATION: MAT060								16/07/11
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.13							
Quality Control									

[Handwritten signature] 16/07/12.

DAS
21
9-89 JUL 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :	MRB (QSI042) Approval		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

Monday, June 27, 2016 11:40:35 AM

Page 1

Work Order ID: 148186

148186

Parent Item: DSK078

DSK078

Parent Item Name: D2893-1 Turning Detail

Start Date: 6/28/2016

Required Date: 7/11/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-005		Manufactured	No				Each	31.0000		8			

D6104-005

Round Billet, 17-4

**

Location

Loc Qty

Loc Code

MAT043

31

144227

11

144957

20

DAS

45

2-89

18 2015-7-9

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																													
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<table style="width:100%; border-collapse: collapse;"> <tr> <th colspan="4" style="text-align: left; padding: 5px;">Root Cause</th> <th colspan="4" style="text-align: left; padding: 5px;">FAULT CATEGORY</th> </tr> <tr> <td style="width:15%;">☐ Environment</td> <td style="width:15%;">☐ Design</td> <td style="width:15%;">☐ Doc/Data</td> <td style="width:15%;">☐ Equip/Tooling</td> <td style="width:15%;">☐ Handling/Pre</td> <td style="width:15%;">☐ Material</td> <td style="width:15%;">☐ Internal Transport</td> <td style="width:15%;">☐ Tribal Knowledge</td> </tr> <tr> <td>☐ LOA</td> <td>☐ Substation</td> <td>☐ Past Expiry Date</td> <td>☐ Misidentified</td> <td>☐ No Re-verification</td> <td>☐ Operator</td> <td>☐ Offset/Setup</td> <td>☐ Supplier</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td>☐ Training</td> <td>☐ Use for Testing</td> <td>☐ Poor Information</td> <td>☐ Rushing</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td>☐ Product Improvement</td> <td>☐ Process Improvement</td> <td>☐ Manufacturing Process</td> <td>☐ Past Due</td> </tr> </table>								Root Cause				FAULT CATEGORY				☐ Environment	☐ Design	☐ Doc/Data	☐ Equip/Tooling	☐ Handling/Pre	☐ Material	☐ Internal Transport	☐ Tribal Knowledge	☐ LOA	☐ Substation	☐ Past Expiry Date	☐ Misidentified	☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier					☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing					☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due
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OTHER : _____																																															

DART

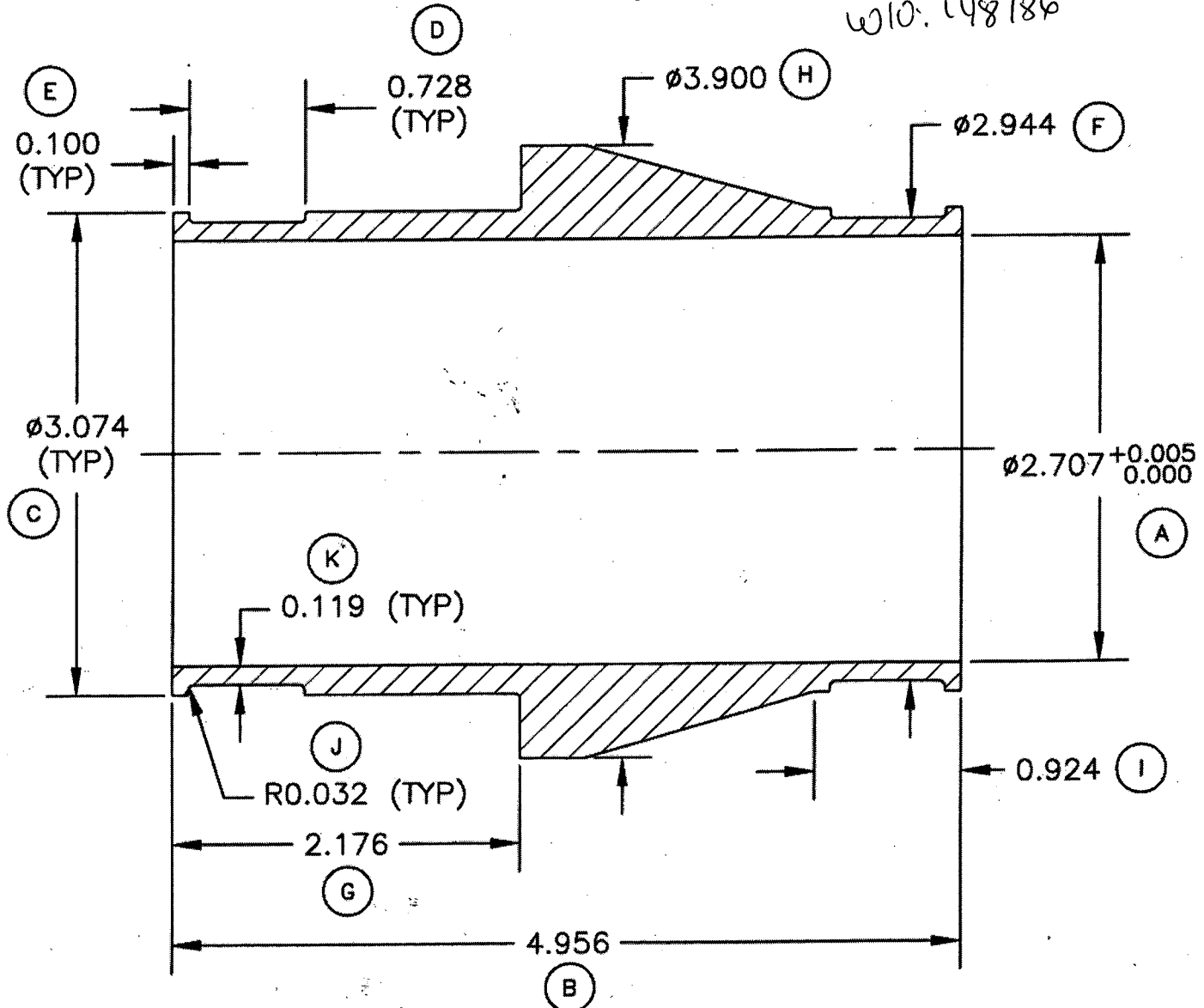
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20	TITLE TURNING DETAIL FOR D2893-1		SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01

JUN 27 2016

DAS
13
9-89

W10. 148186



D2893-1 TURNING DETAIL

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DART AEROSPACE LTD		Work Order:	148186
Description: Turning Detail for D2893-1		Part Number:	DSK078
Inspection Dwg: DSK078		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.709	2.704	2.704	2.704	2.705
B	4.946	4.966		2.958	2.957	2.958	2.958	2.958
C	3.064	3.084		3.075	3.075	3.075	3.075	3.075
D	0.718	0.738		0.728	0.728	0.728	0.728	0.728
E	0.090	0.110		0.100	0.100	0.100	0.100	0.100
F	2.934	2.954		2.945	2.945	2.945	2.945	2.945
G	2.166	2.186		2.176	2.176	2.176	2.176	2.176
H	3.890	3.910		3.900	3.900	3.900	3.900	3.900
I	0.914	0.934		0.924	0.924	0.924	0.924	0.924
J	0.022	0.042		0.032	0.032	0.032	0.032	0.032
K	0.109	0.129		0.120	0.120	0.120	0.120	0.120
L								
M								
N								
O								
P								

Measured by: DAS 45	Date: 2015-7-10
Audited by: DAS 14	Date: 16/07/10
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 148186
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	#6	#7	#8	#	#
Lathe Section								
A	2.707	2.712		2.709	2.709	2.707		
B	4.946	4.966		4.956	4.956	4.956		
C	3.064	3.084		3.075	3.075	3.075		
D	0.718	0.738		0.728	0.728	0.728		
E	0.090	0.110		0.100	0.100	0.100		
F	2.934	2.954		2.945	2.945	2.945		
G	2.166	2.186		2.176	2.176	2.176		
H	3.890	3.910		3.900	3.900	3.900		
I	0.914	0.934		0.924	0.924	0.924		
J	0.022	0.042		0.032	0.032	0.032		
K	0.109	0.129		0.120	0.120	0.122		
L								
M								
N								
O								
P								

DAS
45

Measured by:	45	Date:	2018-7-10
Audited by:	14	Date:	16/07/18
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	